

Work Order ID 82270

82270

Page 1

March-27-12 2:47:31 PM

Item ID: D2576-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step (casting detail)
 Start Date: 27/03/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 10/04/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/27 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2576	Rev G

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 11581 Ship D2576 mould to vendorCast per D2576-1
 Pattern vendor: Alpine Non- FerrousMaterial Release Note Required

12-03-21

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure D2576 mould is returned with the ordered parts Ensure release note is attached

12-04-12

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

8/26/17

asp014

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Start Date: 27/03/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 10/04/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>CNK</u>	0.00							
130									
Packaging	Memo	0.00				50			
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/4/19

MF
12-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-27-12 2:47:35 PM

Page 1

Work Order ID: 82270

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Parent Item: D2576-1

D2576-1

Parent Item Name: Step (casting detail)

Start Date: 27/03/2012

Required Date: 10/04/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev: A New Issue 05-11-29 JLM
IPP rev B rev F dwg 07.07.06 EC
IPP Rev: C As per Rev G 07-09-05 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2576-1P		Purchased	No			100	Each	0.0000	1	50			

D2576-1P

Step (Casting Detail)

**

SP 12-04-12

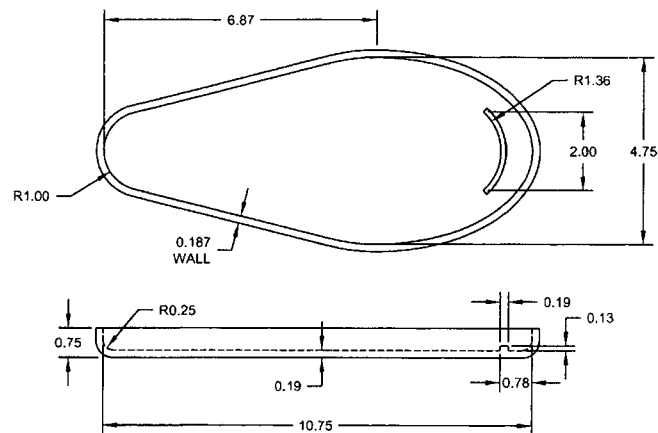
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

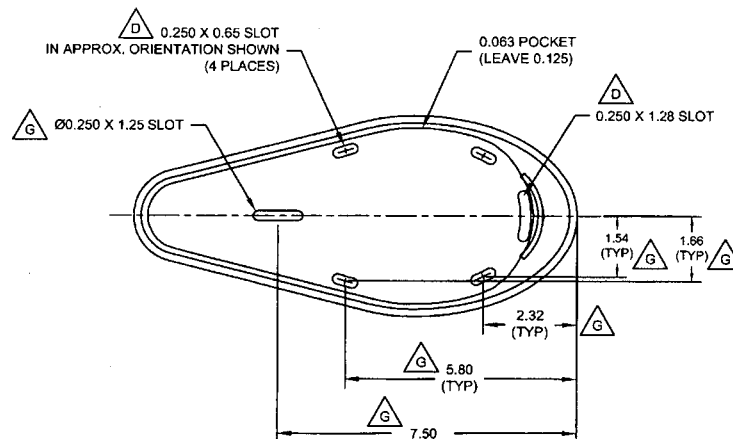
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 02270 MCLJ
12/03/27

RELEASED

07.08.29

DESIGN	4	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. G
MFG. APPR.	PH	D2576	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	STEP	1:3
DATE	07.08.15	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
REV.	DESCRIPTION	BY	DATE
G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

875543200491

875543200491

875543200491

875543200491

Not all services and options available to all destinations. / Certains services et options ne sont pas disponibles pour toutes destinations.

Origin Station ID N.I. de la succ. d'origine	Dest. Station ID N.I. de la succ. dest.	Hold Station ID N.I. de la succ. dét.
Received At / Reçu A 1 <input type="checkbox"/> Reg. Stop / Arrêt régulier 2 <input type="checkbox"/> On-Call Stop / Arrêt sur demande 3 <input type="checkbox"/> Drop box / Boîte à colis 4 <input type="checkbox"/> BSC / Comp. / toir de dépôt 5 <input type="checkbox"/> Station Succursale		
Freight Fret	G.S.T./H.S.T. T.P.S./T.V.H.	P.S.T./O.S.T. T.V.P./T.V.O.
Other Autre		Total

1 From / Expéditeur

Date

Sender's Name
Nom de l'expéditeurPhone
TéléphoneCompany
Nom de la sociétéAddress
Adresse

Dept./Floor/Service/Étage

Address
AdresseCity
Ville

Province

Postal Code
Code postal2 Your Internal Reference
Votre référence interne

3 To / Destinataire

Recipient's Name
Nom du destinatairePhone
TéléphoneCompany
Nom de la sociétéAddress
Adresse

We cannot deliver to P.O. boxes / Nous ne livrons pas aux boîtes postales.

Address
AdresseCity
Ville

Province

Postal Code
Code postal

4 Shipment Information / Informations sur l'envoi

Total Packages
Nombre total de colisTotal Weight
Poids total

lb.

DIM

Poids

VOL

in.

po

cm

Total Declared Value
Valeur totale déclarée

\$

5a Express Package Service / Service colis express

- 1 ☐ FedEx Priority Overnight 6 ☐ FedEx First Overnight 3 ☒ FedEx 2Day
- Higher rates apply.
Des tarifs plus élevés s'appliquent.

5b Express Freight Service / Service fret express

- 7
- ☐
- FedEx 1Day Freight

Booking Number/Numéro de réservation

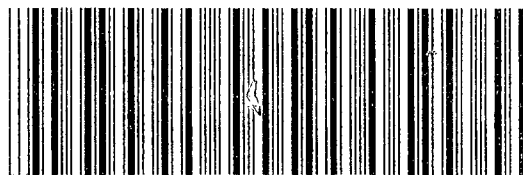
Call 1.866.744.7493 to book shipment / Composez le 1.866.744.7493 pour réserver de l'espace pour votre envoi.

6 Packaging / Emballage

- 6 ☐ FedEx Envelope* 2 ☐ FedEx Pak* 3 ☐ FedEx Box Boîte FedEx 4 ☐ FedEx Tube Tube FedEx 1 ☐ Other

*Declared Value Limit \$100 CDN.
*Limite de valeur déclarée de 100 \$CAN.

FedEx Express

Intra-Canada Air Waybill
Lettre de transport aérien intérieure

7 Special Handling / Manutention spéciale

- 1 ☐ HOLD at FedEx Location / RETENIR à la succursale FedEx
May not be in the same city. Not available for FedEx First Overnight / Peut être située dans une autre ville. Pas disponible pour FedEx First Overnight et FedEx 1Day Freight.
- 3 ☐ SATURDAY Delivery / Livraison le SAMEDI
Available to select locations. Not available for FedEx First Overnight and FedEx 1Day Freight / Disponible à certains endroits. Pas disponible pour FedEx First Overnight et FedEx 1Day Freight.
- Does this shipment contain dangerous goods? / Cet envoi contient-il des marchandises dangereuses?*
- Must check one box / Cocher une seule case.
- 4 ☐ No / Non 5 ☐ Yes / Oui
As per attached Shipper's Declaration / Selon la déclaration de l'expéditeur, ci-jointe.
- 6 ☐ Dry Ice / Dioxyde de carbone, solide
UN 1845 x kg
- *Dangerous goods (including dry ice) cannot be shipped in FedEx packaging / Les marchandises dangereuses (y compris le dioxyde de carbone solide) ne peuvent pas être expédiées dans des emballages FedEx.
- CA ☐ Cargo Aircraft Only / Avion cargo uniquement

8 Payment Bill transportation charges to: / Paiement Facturer le transport à:

- Enter FedEx Acct. No. or Credit Card No. below.
Indiquer ci-dessous le n° de compte FedEx ou de la carte de crédit.
- 1 ☐ Sender / Expéditeur
Acct. No. in Section 1 will be billed / Les frais seront imputés au numéro de compte figurant à la rubrique 1.
- 2 ☒ Recipient / Destinataire
- 3 ☐ Third Party / Tierce partie
- 4 ☐ Credit Card / Carte de crédit
- 5 ☐ Cash / Cheque / Argent liquide / Chèque
- Credit Card Exp. Date / Date d'expiration de la carte de crédit
- Credit Card Auth. / Autorisation de carte de crédit

9 Sign to Authorize Delivery Without a Signature / Signer pour autoriser la livraison sans signature

Sender authorizes FedEx to deliver this shipment without obtaining a delivery signature and shall indemnify and hold harmless FedEx from any claims resulting therefrom. / L'expéditeur autorise FedEx à livrer le présent colis sans avoir obtenu de signature attestant de la livraison et libère FedEx de toute réclamation pouvant en résulter.

Sender's Signature
Signature de l'expéditeur

10 Required Signature / Signature requise

Sender's signature and liability limitation / Signature de l'expéditeur et limite de responsabilité

Use of this Air Waybill constitutes your agreement to all the terms and conditions on the back of this Air Waybill and in the current FedEx Service Guide, which may limit our liability for damage, loss, delay, shortage, misdelivery, misinformation, or failure to provide information in connection with your shipment. Features of service may vary from location to location. See the current FedEx Service Guide or call 1.800.GoFedEx 1.800.463.3339 for further information.

En utilisant cette lettre de transport aérien, vous acceptez les clauses et conditions qui figurent au verso de celle-ci ainsi que dans le Guide des services de FedEx actuel, clauses qui peuvent limiter notre responsabilité à l'égard des dommages, pertes, retards, livraisons incomplètes, livraisons erronées, informations fautives ou incapacité de fournir de l'information sur votre envoi. Les modalités de service peuvent varier d'un endroit à l'autre. Voir le Guide des services de FedEx actuel ou téléphoner au 1.800.GoFedEx 1.800.463.3339 pour plus d'information.

Sender's Signature
Signature de l'expéditeur

PART 157259
Rev. Date 5/06
©1994-2006 FedEx
PRINTED IN U.S.A. R01A

548

FedEx Tracking
Number
Numéro de suivi FedEx

8755 4320 0491

0450

Form
ID No
N° du
formulaire

07/11



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO16581**

Purchase Order Date 3/28/2012

PO Print Date 3/28/2012

Page Number 1 of 1

Order From :

VC-ALP001

ALPINE NON-FERROUS FOUNDRY
8657 - 132ND STREET
SURREY, BC V3W 4P1
CA

Contact Name
Vendor Phone 604 596 8080
Vendor Fax 604 596 8045
Vendor Account Nbr

Buyer Brigitte Golden
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2576-1P	Step (Casting Detail)	4/13/2012 Yes	50.00 Each	FedEx Overnigh	\$17.7590	\$887.50

Special Inst: As per DWG: D2576 Rev: G
B82270

PO Total: \$887.50

*Please advise on \$ & delivery:
bgolden@dartaero.com
thx*

Change Nbr: 1

Change Date: 3/28/2012

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

TRANSMISSION VERIFICATION REPORT

TIME : 03/28/2012 09:00
NAME :
FAX :
TEL :
SER.# : F9N212739

DATE, TIME	03/28 08:59
FAX NO./NAME	16045968045
DURATION	00:00:32
PAGE(S)	02
RESULT	OK
MODE	STANDARD
	ECM

ALPINE NON-FERROUS FOUNDRY8657-132ND STREET
SURREY, B.C. V3W 4P1**WORK ORDER**

Tel: (604) 596-8080 Fax: (604) 596-8045

Sold To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA**Ship To: DART AEROSPACE**

Order Date		Purchase Order#	Due Date	Ship Via			Page
28-Mar-12		PO16581	13-Apr-12	FEDEX			1
Item#	Item Code	Description	Material	Ordered	B/O	Qty Ready	Qty Shi
1	DART D2576	D2576 STEP CSTG 8170117	535	50			50

Comments

Castings&Patterns are property of Alpine until paid in full

PACKING SLIP

BECK ALUMINUM LEBANON

Division of Beck Aluminum Alloys LTD

24 KEYSTONE DRIVE

LEBANON, PA 17042

Telephone: 717/277-0300

Fax: 717/277-0310

3132945

Ship Date 02/

Sold To:

RYPAC ALUMINUM RECYCLING LTD.
11849 TANNERY RD.
SURREY, BC V3V 3W8
CANADA

Ship To:

RYPAC ALUMINUM RECYCLING LTD.
11849 TANNERY RD.
SURREY, BC V3V 3W8
CANADA

CHEMICAL ANALYSIS - ELEMENTS LESS THAN 0.01% MAY NOT BE REPORTED

Customer	Ship Via	F.O.B.	Terms
RYPAL	CPU # 2675	LEBANON, PA	Net 30 Days
Purchase Order Number		Salesperson	Order Date
2553		JM	01/30/12
Item Number / Item Description		Our Order Number	
1535.2 - PRIMARY ALUMINUM INGOT		327817	

Customer Item Code:

Heat #	LBS	SI	FE	CU	MN	MG	CR	NI	ZN	TI	PB	SN	SR
X34800-043	2104	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-044	2068	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-045	1936	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-046	2098	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-047	1910	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-048	1812	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-049	1844	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-050	1922	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-051	2122	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-052	2074	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-053	2054	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-054	1986	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-055	1990	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-056	1974	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-057	1912	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-058	1886	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-059	1886	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-060	1964	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-061	2106	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-062	1808	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-063	1988	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
X34800-064	1956	0.07	0.08	0.00	0.19	7.22	0.00	0.00	0.01	0.18	0.00	0.00	0.00
Weighted Avg.		0.070	0.080	0.000	0.190	7.220	0.000	0.000	0.010	0.180	0.000	0.000	0.000

Special Requirements: INVOICE, PACKING LIST AND COA FAXED OR EMAILED ASAP.

Delivery Information: CPU, Van

Total 43400

CAUTION: INGOTS ARE SUBJECT TO THE FORMATION OF SHRINKAGE CAVITIES WHICH MAY ENTRAP MOISTURE: SUCH MOISTURE CAN CAUSE AN EXPLOSION HAZARD. TO MINIMIZE THIS HAZARD, ALL INGOTS MUST BE THOROUGHLY DRIED TO REMOVE ANY ENTRAPPED MOISTURE BEFORE CHARGING THEM INTO MOLTEN METAL

Authorized Signature

Date